

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008562**Date Inspected:** 15-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin, Wang Chuangning**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

**TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress.

**OBG SEGMENT-1AAW-1AW**

FCAW welding process of weld joint 953 located on PCMK SEG1E. Welder is identified as 220067 ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 968 located on PCMK SEG1E. Welder is identified as 220066 ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

**BK-03**

FCAW welding process of weld joint 009 located on PCMK BK-03. Welder is identified as 220077 ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U4C-F.

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BK-02

FCAW welding process of weld joint 006 located on BK-02. Welder is identified as 220077ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U4-C-F.

BAY#10

FCAW welding process of weld joint 84B located on PCMK NSTL-3B/K. Welder is identified as 054069 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

FCAW welding process of weld joint 83B located on PCMK NSTL-3B/K. Welder is identified as 052075 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-TC-U5-F.

INCIDENT

OBG SEGMENT-1AW

This Quality Assurance Inspector (QA) observed that the contractor appears to have deviated from the weld joint design specified on the approved drawings. The contractor appears to have changed the weld joint from a fillet weld to a Complete Joint Penetration (CJP) weld without the Engineers approval. The root opening was measured more than 16mm. This condition exists on weld joining floor beam to side panel on OBG segment 1AW @ panel point PP08.5 counterweight side. The weld is identified as SSD34-PP08.5-84/83. For additional information see the attached photos. Incident report was sent to task leader and other supervisor.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant conversation

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Utekar,Shrikant
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William
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QA Reviewer
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